

**Work Order ID 60444**

Wednesday, July 07, 2010 3:28:57 PM

Page 1

Item ID: D2421

Accept

Revision ID:

Item Name: Bearpaw, 900

Start Date: 7/7/2010 Start Qty: 8.00

Required Date: 7/14/2010 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: MUF Date: 10-7-7 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D242 Rev F2

120



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

Cut Blank as per file D2421\_BLANK

0.00

0.00

130



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio FA124 and Dwg D2421  
Identify as D2421  
3-Deburr

0.00

0.00

B 10-7-19

⑧

7 1

PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: 02421 PAR #: \_\_\_\_\_ Fault Category: Misalignment NCR: ☒ Yes No DQA: [Signature] Date: 10/07/26  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/07/29

NCR: <u>60444</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/07/25	130	One Bear pawl is affected By pocket was too deep By .250". R.L. operator error Bad origin (L, O, A)	<u>[Signature]</u> OS1042	no replace. - Scrap & destroy	<u>[Signature]</u> 10/07/25	<u>[Signature]</u> 10/07/26	<u>[Signature]</u> OS1042	<u>[Signature]</u> 10/07-26

NOTE: Date & initial all entries

**Work Order ID 60444**

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Item ID: D2421

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Required Date: 7/14/2010 Req'd Qty: 8.00

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

BP 10/07/25

7

1

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

amk 10/07/27

7

1

151

Identify as per dwg &amp; Stock Location: \_\_\_\_\_ 0.00



Packaging

Memo

0.00

Packaging

PPD 60443

Curry 7/28 (7)

**Work Order ID 60444**

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Item ID: D2421

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw, 900

Start Date: 7/7/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 7/14/2010 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/29 *[Signature]*  
10-7-28  
(8)

# Picklist Print

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Page 1

Work Order ID: 60444



Parent Item: D2421

Parent Item Name: Bearpaw, 900

Start Date: 7/7/2010

Required Date: 7/14/2010

Start Qty: 8.00

Required Qty: 8.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

227.7473

4

32



UHMW 1" Black



10-7-19

### Location

MAT

113903

114624

### Loc Qty

227.7473

86.9473

140.8

### Loc Code

114624

8

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 60444
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2421
<b>Inspection Dwg:</b> D2421 <b>Rev:</b> F2		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.20	+/-0.030	.190	✓		Dept Mics 8809	
B	0.95	+/-0.030	.946	✓		vern 8812	
C	0.45	+/-0.010	.453	✓		"	
D	0.07 x 45°	+0.030/-0.010	.070	✓		"	
E	0.69	+/-0.030	.690	✓		"	
F	0.38	+/-0.010	.386	✓		Mics 118-120	
G	0.44 - 0.47	+/-0.000	.450	✓		vern 8812	
H	R0.25	+/-0.030	.250	✓		"	
I	0.19 x 45°	+/-0.030	.19	✓		"	
J	23.00	+/-0.030	23.00	✓		Tap	
K	Ø0.260	+0.005/-0.000	.260	✓		vern	
L	Ø0.93	+/-0.030	.921	✓		"	
M	0.30	+/-0.030	.315	✓		"	
N	4.50	+/-0.030	4.50	✓		"	
O	9.50	+/-0.030	9.50	✓		vern	
P	1.00	+/-0.030	1.00	✓		vern 8812	
Q	14.750	+/-0.010	14.75	✓		Tap cm oz	
R	0.38	+/-0.030	.38	✓		vern	
S	4.54	+/-0.010	4.54	✓		"	
T	19.00	+/-0.030	19.00	✓		Tap	

<b>Measured by:</b> <i>SS</i>	<b>Audited by:</b> <i>cmk</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/07/25	<b>Date:</b> 10/07/27	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	
B	04.11.29	Revised dimension M	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

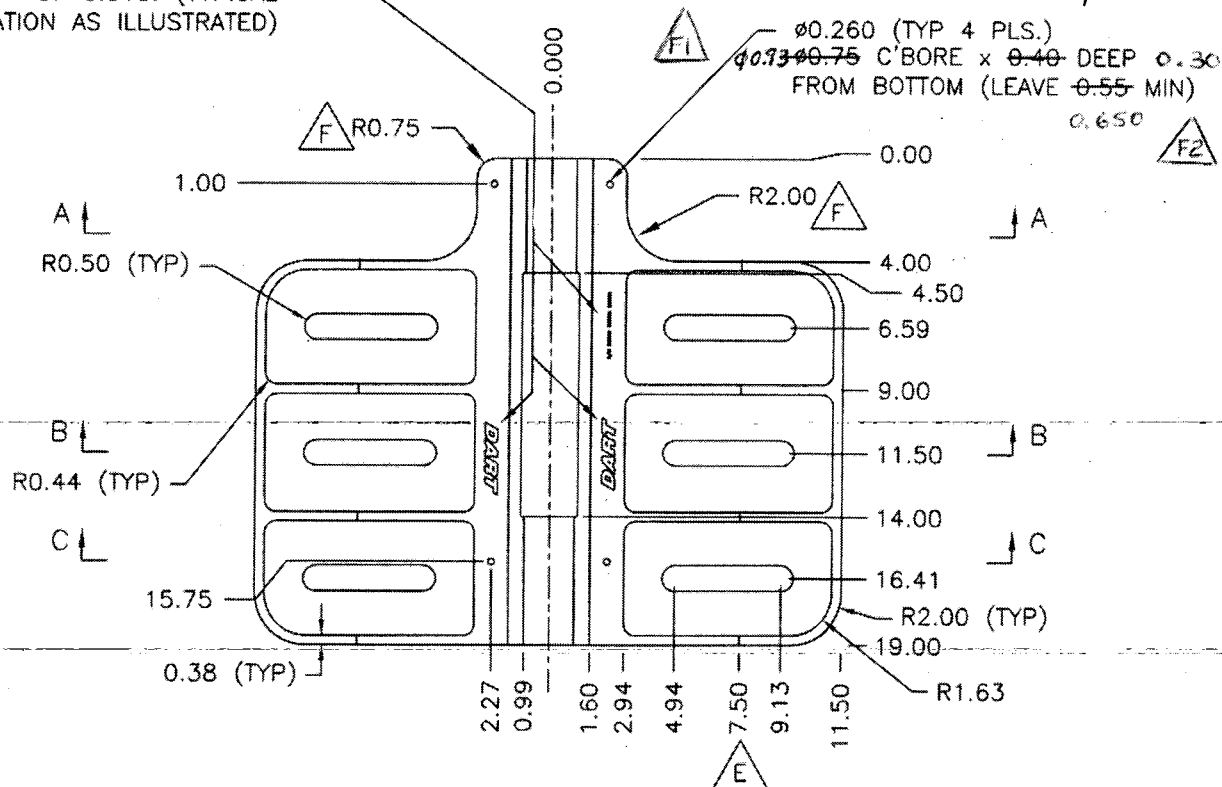
**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED #	DRAWING NO. D2421	REV. F SHEET 1 OF 2
DATE 01.03.12		TITLE BEARPAW	SCALE 1:1
A	95.04.24	NEW ISSUE	
B	95.11.28	CHANGED NUMBER OF HOLES	
C	97.06.19	ADDED MATERIAL SPECIFICATION	
D	98.08.11	DIM MODIFICATIONS	
E	00.03.01	R1.77 WAS R2.66; ADD R1.85 BORE RELIEF FOR CLAMPS; ADDED DEO 9155	
F	01.03.12	MODIFY FWD END	
F1	# 03.01.13	$\phi 0.93$ WAS $\phi 0.75$ ; R0.19 WAS R0.38; 0.19 WAS 0.25	
F2	# 04.11.03	0.30 WAS 0.40; 0.650 WAS 0.55	

RELEASED  
01.03.14

ENGRAVE DART LOGO TO  
MAX DEPTH OF 0.012.  
ENGRAVE PART AND BATCH  
NUMBERS TO MAX DEPTH  
OF 0.010. (TYPICAL  
LOCATION AS ILLUSTRATED)



SYMMETRIC ABOUT CENTER LINE

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689,  
1.00" THICK (MACHINE TO 0.950)

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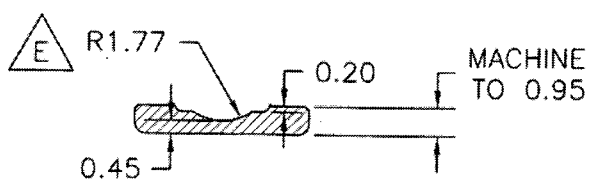
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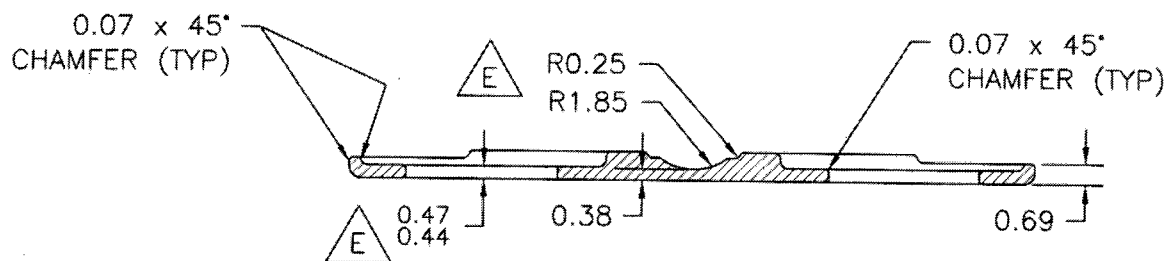


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RT	APPROVED #	DRAWING NO. D2421	REV. F SHEET 2 OF 2
DATE 01.03.12	TITLE BEARPAW SCALE 1:6		

RELEASED  
01.03.14 #

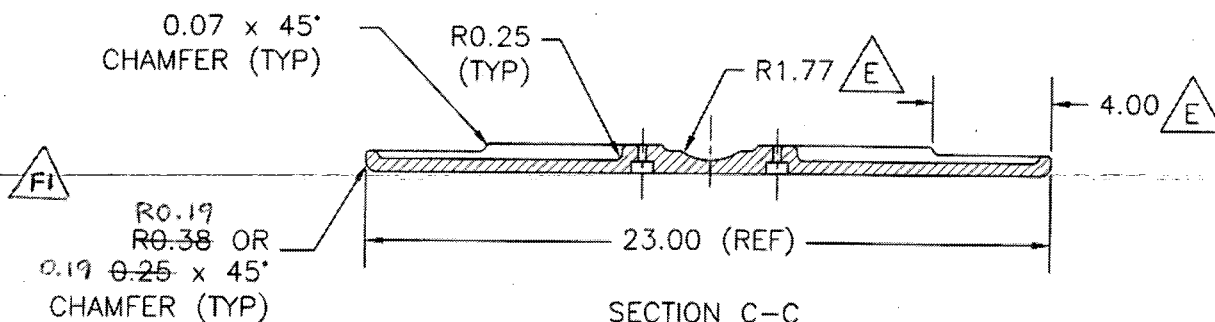


SECTION A-A



SECTION B-B

# 60444



SECTION C-C

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